

Date: Monday, 7/9/2007 3:44:07 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RING
Job Number : 33432	
Estimate Number : 10858	
P.O. Number : N/A	Part Number : D34075
This Issue : 7/9/2007 S.O. No. : N/A	Drawing Number : D3407 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C
Previous Run : 32900	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 7/27/2007
Checked & Approved By : <u>[Signature]</u>	Qty: 28 Um: Each
Comment : Est Rev: A New Issue 05-11-22 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174R3000	Inventory
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Comment: Qty.: 0.0306 f(s)/Unit Total : 0.6111 f(s) 1.2  
 Material: 17-4ph SS Round Bar Ø3.000(M17-4-R3.000)  
 Identify for D3407-5  
 Batch: M18742

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per Folio FA598 Rev: AA & Dwg D3407 Rev: C

2-Deburr

BL 07.11.20 (28)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BL 07.11.20 (28)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mk 07/11/21 (28)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PAT

BL 07/11/21 (28)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 21/11/22

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 33432

Part Number: D34075

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



28

Comment: FINAL INSPECTION/W/O RELEASE

9/27/11/22

Job Completion



U 8.11-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

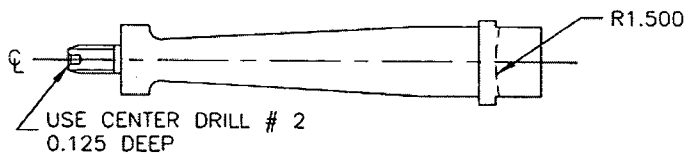
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

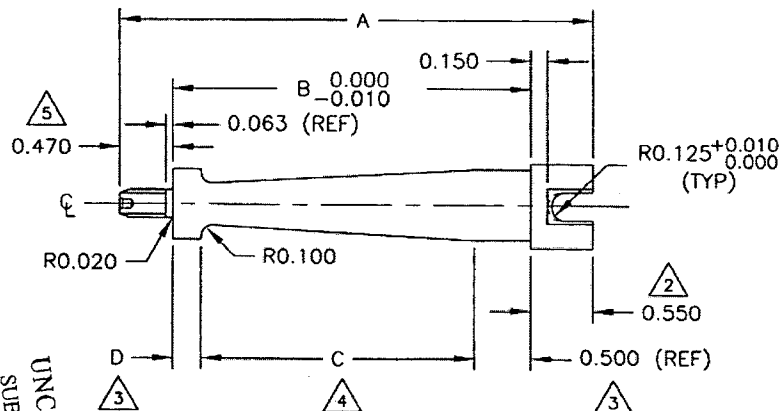
NOTE: Date & initial all entries





RELEASED

05.09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

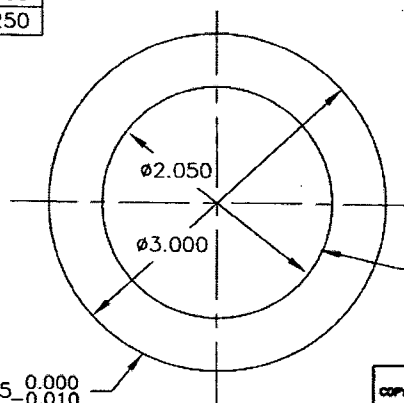
### D3407-1/-3 STEM

### D3407-1 AND D3407-3 STEM:

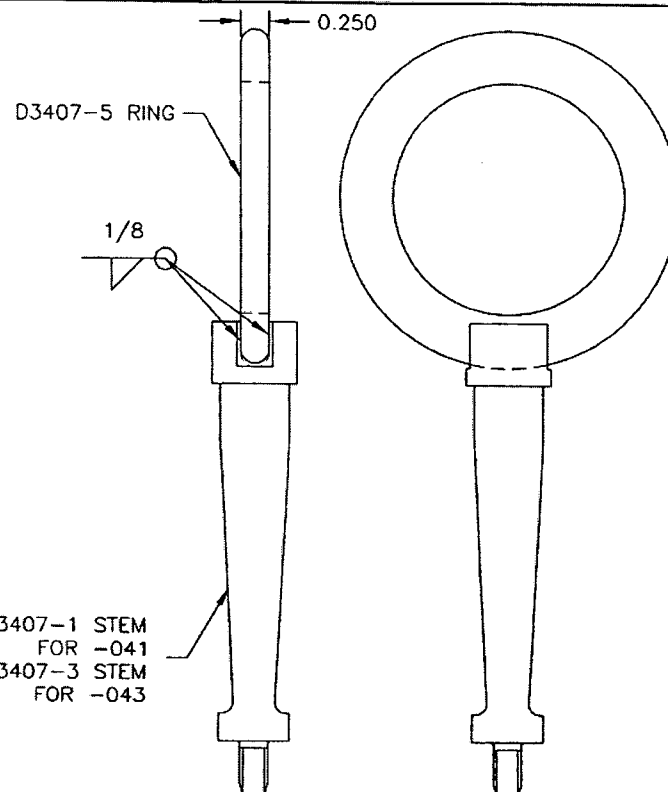
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) Ø0.750 O.D.
- 3) Ø0.625 O.D.
- 4) MACHINE UNIFORM TAPER FROM Ø0.363 O.D. TO Ø0.625 O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

### D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



### D3407-5 RING



USE D3407-1 STEM  
FOR -041  
USE D3407-3 STEM  
FOR -043

### D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DART AEROSPACE USA, INC.
DRAWN BY	CP	PORT HANCOCK, VA
CHECKED	CP	DART AEROSPACE USA, INC.
APPROVED	CP	DART AEROSPACE USA, INC.
DRAWING NO.	D3407	REV. 0
DATE	05.09.09	SHEET 1 OF 1
TITLE	TOW RING	SCALE
		1:1

NO. 33432

WORK ORDER  
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WITHOUT NOTICE